

Work Order ID 80167

February-13-12 10:37:12 AM

80167

Page 1

Item ID: D3289-041 Accept ***N9000040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Float Web (206A/B)
 Start Date: 13/02/2012 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 27/02/2012 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: M.L.S Date: 12/02/13 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3289	Rev D

100	Skid tubes	0.00							
100									
Skid tubes									
Skid tubes									
	Memo	0.00							
	[1-Cut D2600-5-108 to as per Dwg D32892 Transfer drill web from D3283-3 doublers3-Drill web using DT 8748 as per Dwg D32894-Using uni-bit, open holes as per Dwg D32895-Deburr holes and ends								
110	QC5- Inspect part completeness to step on W/O	0.00							
110									
QC									
Quality Control	Memo	0.00							
120	Chemical Conversion Coat per QSI005 4.1	0.00							
120									
Hand Finish									
Hand Finishing	Memo	0.00							

PL 12/02/17 BB 12/02/22

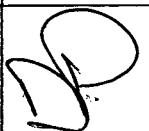


DP 12-2-22

B 12/02/22

Dart Aerospace Ltd

W/O: 80167		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3289-041 PAR #: _____ Fault Category: Supplier NCR: Yes No DQA: _____ Date: _____
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12-2-17	100	Found 2 D2600-S-108 Twisted 0.500" C-378909		Scrap	DL 12/02/17	 12-2-17	 12-02-17	 12/02/17

NOTE: Date & initial all entries

Work Order ID 80167

80167

Page 2

February-13-12 10:37:12 AM

Item ID: D3289-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Float Web (206A/B)
 Start Date: 13/02/2012 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 27/02/2012 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC3- Inspect Part Finish <i>QC7</i> Memo	0.00 0.00							
140 *140* Skidtubes Skidtubes	Skidtubes Memo 1- Apply LPS between doublers and web as per dwg D32892- Coat rivets with LPS- Rivet doublers as per dwg D3289A/R LPS-3 Batch: <i>M118614</i>	0.00 0.00							
150 *150* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							

DP 12-2-22
 (2) PTO
 (2) SAD 12-02-23
 12-02-23 (2)

Dart Aerospace Ltd

W/O: 80163		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
12-2-22	130	Should read QC 7	DP DA	12-2-22		W 12/2/22	S 12/2/22	
12-2-22	140	No LPS-3				ip 12-2-22 451 042	S 12/2/22	

Part No: D 3289-041 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 80167

80167

Page 3

February-13-12 10:37:12 AM

Item ID: D3289-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Float Web (206A/B)

Start Date: 13/02/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 27/02/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

Identify as per dwg & Stock Location: LG

0.00

160

Packaging

Memo

0.00

Packaging

② SAD 12-02-23

170

QC21- Final Inspection - Work Order Release

0.00

170

QC

Memo

0.00

Quality Control

M.L.J 12/02/23

R12-02-23
②

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

February-13-12 10:37:16 AM

Page 1

Work Order ID: 80167

80167

Parent Item: D3289-041

D3289-041

Parent Item Name: Float Web (206A/B)

Start Date: 13/02/2012

Required Date: 27/02/2012

Start Qty: 2.00

Required Qty: 2.00

Comments:

IPP Rev:A04.09.28New IssueKJ/JLM

IPP Rev:B 07-09-09 As per Rev C JLM Verified By:EC

IPP Rev:C 07-12-06 as per Rev D DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

MS20470AD4-7

Purchased

No

100

Each

704.0000

85

170

MS20470AD4-7

Rivet, Universal Head

**

SAD

12-02-23

Location

Loc Qty

Loc Code

ST320

704

116081

117

117887

269

118614

318

170

D2600-5-108

Manufactured

No

140

Each

227.0000

1

2

D2600-5-108

Extrusion 'I Beam' thin

**

DE 12/02/17

Location

Loc Qty

Loc Code

LG

227

47814

20

73909

207

2

D3283-3

Manufactured

No

140

Each

57.0000

2

4

D3283-3

Doubler

**

4 SAD 12-02-23

Location

Loc Qty

Loc Code

Mezz

57

25879

16

26793

1

37371

40

B 80356

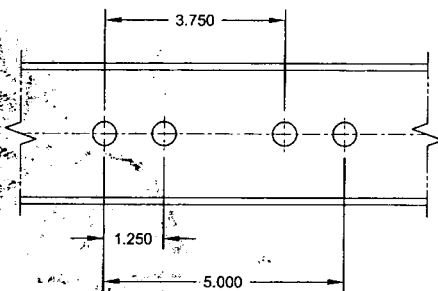
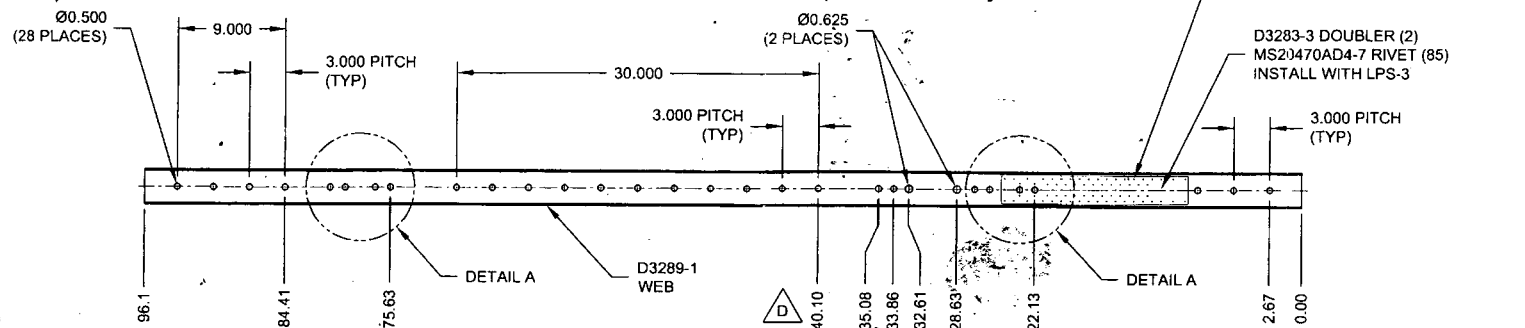
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DETAIL A
(RIVET HOLES NOT SHOWN)
SCALE 1:5

D3289-041 FLOAT WEB

Qty	Part Number	Description
X	D3289-041	FLOAT WEB
1	D2600-5-108	EXTRUSION
2	D3283-3	DOUBLER
85	MS20470AD4-7	RIVET

NOTES:

- 1) MATERIAL: MAKE FROM D2600-5-108 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
- 6) APPLY A LAYER OF LPS LABORATORIES' LPS-3 BETWEEN D3283-3 DOUBLERS AND D3289-1 WEB. INSTALL RIVETS COATED IN LPS LABORATORIES' LPS-3
- 7) WEIGHT: 5.00 lbs

80167 H.C.S
12/02/13

RELEASED
07/11/13

D	MID-FLOAT HOLES ON D3288 WERE MOVED 2.00" FWD & ROTATED INBOARD & OUTBOARD BY 17° DUE TO GHW INTERFERENCE. THEREFORE, 40.10 WAS 38.10.	MB	07.09.14
C	CORRECTED TYPO (-3 WAS -1)	MB	07.06.04
B	ADD HOLES FOR OEM COMPATIBILITY	CP	05.03.16
A	NEW ISSUE	CP	04.05.18
REV.	DESCRIPTION	BY	DATE
DESIGN	9P		
DRAWN	1		
CHECKED	24		
MFG. APPR.	13		
APPROVED	47		
DE APPR.	1		
DATE	07.09.14		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3289 REV. D SHEET 1 OF 1 TITLE: FLOAT WEB, 206A/B SCALE: 1:10 COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

NID

07.12.12

052802

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries